

Work Order ID 63377

Thursday, October 28, 2010 10:22:23 AM

Page 1

Item ID: D206-642-541

Accept

Revision ID:

Item Name: Replacement Skidtube

Start Date: 10/28/2010 Start Qty: 1.00

Required Date: 11/11/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-541 CHG003

N/A CY 10/12/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

VERIFY AND INSPECT THE MATERIAL PRIOR TO USE*

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

SAD 10-11-03 ①

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

BE 10-11-04

3- weld fwd cap as per dwg D3274 and OSI004

AR Aluminum Rod Batch: min 1385

BE 10-11-04

4- grind fwd cap weld on top surface only

BE 10-11-04

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.
Drill 3/16" pilot holes as per Dwg D3274

BB

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

10/11/09

10/11/11
114 QC 10
116 QC 5

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Date:

Stop

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DescriptionSet Up/
Run Hours

Tool ID

Tool #
Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1

BB
10/11/09

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1

Ø

BE 10/11/10

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

N/A

10.11.11

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Skidtubes

Skidtubes

0.00

Memo

0.00

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☒ Mill 040 ☐

Sikaflex expire date: ☐ 11-9-30 ☐

Start: ☐ 10-11-10 Time: ☐ 11AM ☐

Finish: ☐ Time: ☐

(Adhere for 12 hours)

160



QC

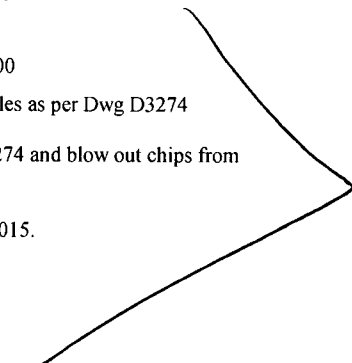
QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control



10-11-11



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Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

L2 3.060

L2 4.60

Solutions

BE 10/11/16

BB

10/11/17

(76)

W/O		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod A/R □ □ Aluminum Rod □ <i>M111385 BE 10/11/22</i>								
	3-Grind cross bolt welds flush as per Dwg D3274.								
	4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.								
200	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

200



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

BE 10/11/22
3 BE 10/11/22

S 10/11/23

W/O:		WORK ORDER CHANGES					
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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

220

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M115951

8:25

320

8:55

1 OK 10-11-29

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		1011129		1	0		
250 HandFinish Hand Finishing	HandFinishing Memo 1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/R <input type="checkbox"/> N/A <input type="checkbox"/> LPS-3 <input type="checkbox"/> 2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/R <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> <input type="checkbox"/> Sikaflex expire date: <input type="checkbox"/>	0.00 0.00		1011129		1	0		
260 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Inspect Nut Plate & Inserts	0.00 0.00							

10 11 29 (1)

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270



HandFinish

Hand Finishing

HAND FINISHING RESOURCE #1

0.00

0.00

Memo

✓ 1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

✓ A/R ☐ Sikaflex-291 ☐ 11/15/14

Sikaflex expire date: ☐ 11/10/14

3-Inspect for foreign objects as per QSI 024

✓ 4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: N/A

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

✓ A/R ☐ Sikaflex-291 ☐ 11/15/14

Sikaflex expire date: ☐ 11/10/14

280



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

BL/mc 10 12 09 (1)

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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
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DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

290

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

PN 63381

0.00

Packaging

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/12/13

ME
10-12-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Required Qty: 1.00

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-190  Extrusion Round 3" 206		Manufactured	No			110	Each	63.0000	1	1			


Location	Loc Qty	Loc Code
LG	63	
47575	15	
59874	48	

SAD 10-11-03

D3285-1  Cap		Manufactured	No			110	Each	141.0000	1	1			
--	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
LG	141	
52511	74	
52647	67	

BE 10-11-04

D3282-041  Float Web (206L/407)		Manufactured	No			150	Each	0.0000	1	1			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

B60931

DP 10-11-11

W/O:		WORK ORDER CHANGES					
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Start Qty: 1.00

Required Qty: 1.00

D2649 Manufactured No 190 Each 107.0000 12 12



Cross Bolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	107	
58545	2	
60652	4	
61496	13	
62889	88	

63359 12 BE n/n/22

D3275-1 Manufactured No 190 Each 216.0000 12 12



Crossbolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	216	
53453	8	
61646	102	
62399	106	

12 BE 10/11/22

CR3212-4-03 Purchased No 250 Each 1,874.000 2



Cherry Rivet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST311	1874	
111359	5	
112314	2	
114436	448	
114450	71	
114859	1348	

2 10/11/29

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Shop Packet Print

Page 2

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Start Qty: 1.00

Required Qty: 1.00

D3415-041 Manufactured No 250 Each 52.0000 1 1

 Nut Plate  1011129



Location Loc Qty Loc Code

ST056 52
 33842 52

CCR264SS3-3 Purchased No 250 Each 416.0000 2 2

 Cherry Rivet  1011129

Location Loc Qty Loc Code

ST311 416
 112314 4
 113539 44
 113973 368

ALS4-1032-130 Purchased No 250 Each 2,653.000 78 78

 Insert  101112

Location Loc Qty Loc Code

PKG11 886
 114723 886
 ST282 1728
 110511 10
 115911 1718
 ST381 39
 114654 39

1116 049 x78

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Start Qty: 1.00

Required Qty: 1.00

D3536-15 Manufactured No 270 Each 18.0000 1 1
Gasket
JH 10/12/09

Location	Loc Qty	Loc Code
FP	6	B63568
56055	1	
60875	5	
FP11	12	
59238	1	
62459	11	

D3536-23 Manufactured No 270 Each 3.0000 1 1
Gasket
JH 10/12/09

Location	Loc Qty	Loc Code
FP011	3	B63238
61237	3	

D3536-35 Manufactured No 270 Each 16.0000 1 1
Gasket
JH 10/12/09

Location	Loc Qty	Loc Code
FP012	16	B63579
58683	1	
61692	3	
62462	12	

D3536-39 Manufactured No 270 Each 12.0000 1 1
Gasket
JH 10/12/09

Location	Loc Qty	Loc Code
FP12	12	B63578
58215	1	
58571	11	

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Thursday, October 28, 2010 10:22:32 AM

Page 5

Work Order ID: 63377

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010



Required Date: 11/11/2010

Start Qty: 1.00



Required Qty: 1.00

D3535-15 Manufactured No 270 Each 22.0000 1 1

 Wearshoe  yl 10/12/09

Location	Loc Qty	Loc Code
FP18	22	B63569
61241	6	
62241	3	
62707	13	

D3535-35 Manufactured No 270 Each 26.0000 1 1

 Wearshoe  yl 10/12/09

Location	Loc Qty	Loc Code
FP018	26	
60865	6	
62461	12	
62969	8	

D3535-39 Manufactured No 270 Each 27.0000 1 1

 Wearshoe  yl 10/12/09

Location	Loc Qty	Loc Code
FP18	27	
60233	16	
62945	11	

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:22:32 AM

Page 6

Work Order ID: 63377

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010



Required Date: 11/11/2010

Start Qty: 1.00



Required Qty: 1.00

D3535-23 Manufactured No 270 Each 28.0000 1 1

 Wearshoe  xl 10/02/09

Location	Loc Qty	Loc Code
FP	7	
61830	6	
FP021	21	
60231	8	
62706	13	

D3537-3 Manufactured No 270 Each 40.0000 1 1

 Wearpad  xl 10/02/09

Location	Loc Qty	Loc Code
FP17	40	
60866	3	
61674	17	
62705	20	

D3537-1 Manufactured No 270 Each 66.0000 9 9

 Wearpad  xl 10/02/09

Location	Loc Qty	Loc Code
FP	1	B63545
55465	1	
FP017	59	
61986	15	
62209	44	
FP17	6	
57713	3	
60491	3	

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:22:32 AM

Page 7

Work Order ID: 63377

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

270

Each

29.0000

80

80



washer



JL 10/12/09

Location

Loc Qty

Loc Code

ST245

29

1115832

x80

107534

29

AN960C416 NAS1149C0463 Purchased No

270

Each

30.0000

1

1



washer



JL 10/12/09

Location

Loc Qty

Loc Code

ST346

30

1115358

x1

100993

30

D3672-1 Manufactured No

270

Each

847.0000

2

2



Phenolic Washer



JL 10/12/09

Location

Loc Qty

Loc Code

ST077

847

42329

150

52505

697

x2

Thursday, October 28, 2010 10:22:32 AM

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 63377

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

270

Each

2,233.000

80

80



BOLT



10/12/09

Location

Loc Qty

Loc Code

ST303

3

115438

3

ST350

2230

114108

14

114416

12

114523

2

115300

202

115589

1000

115936

1000

x80

AN4C5A

Purchased

No

270

Each

481.0000

1

1



BOLT



10/12/09

Location

Loc Qty

Loc Code

ST346

481

110552

4

112243

477

x1

D2646

Manufactured

No

270

Each

45.0000

1

1



Aft Cap



10/12/09

Location

Loc Qty

Loc Code

FP-4

35

57332

35

fp5

6

62652

6

FP6

4

52663

4

x1

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 9

Work Order ID: 63377

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

270

Each

23.0000

1

1



Ring



10/12/09

Location

Loc Qty

Loc Code

ST473

23

B62961

X1

51586

1

53446

7

61322

15

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY SCALE NTS	
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED

07.02.12 [Signature]

DEO ATTACHED

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 43377

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

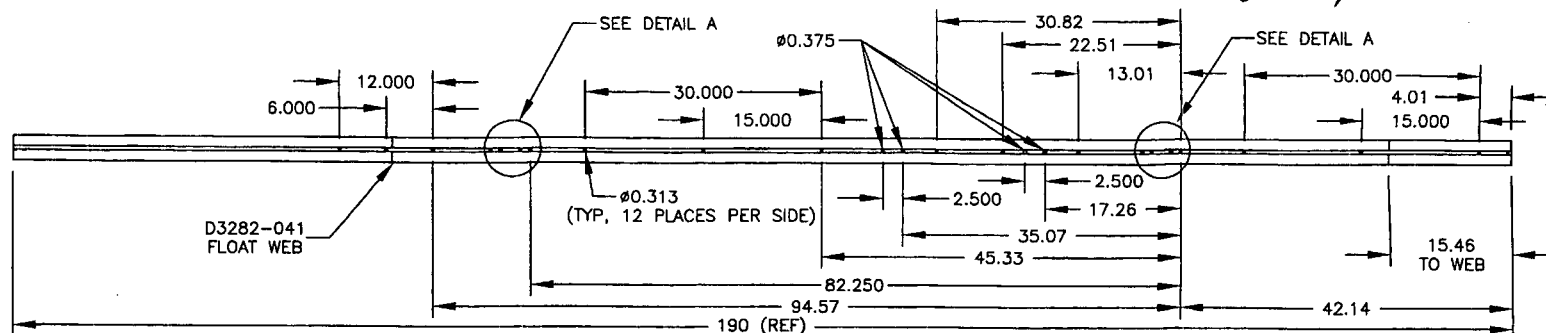
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

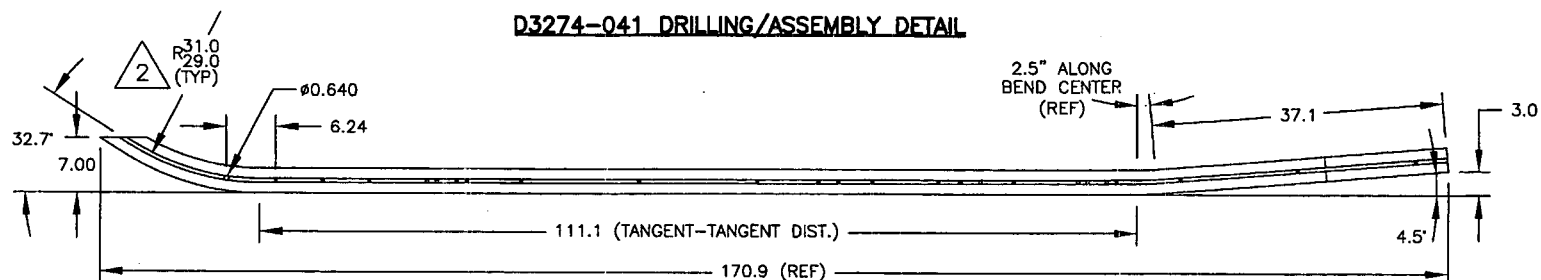
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

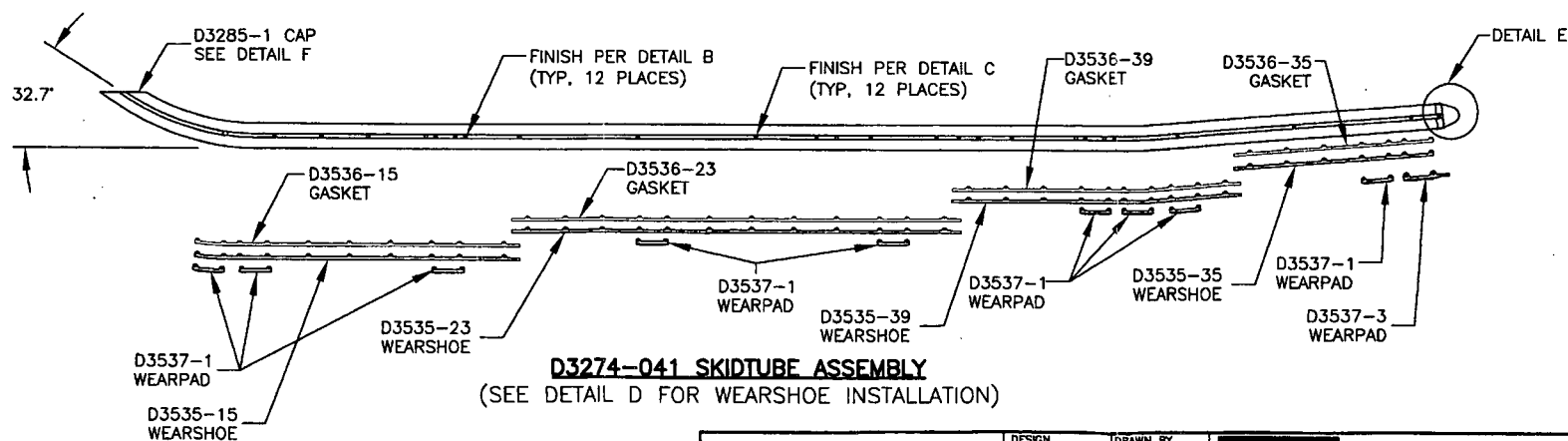
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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07.02.12

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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA	REV. D
CHECKED	H	APPROVED	H	DRAWING NO. D3274	SHEET 2 OF 4
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	SCALE	1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

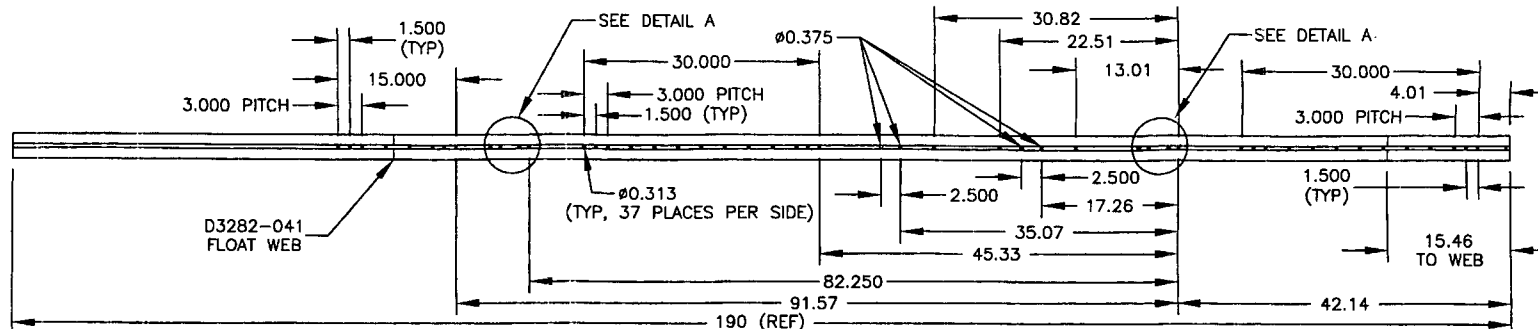
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

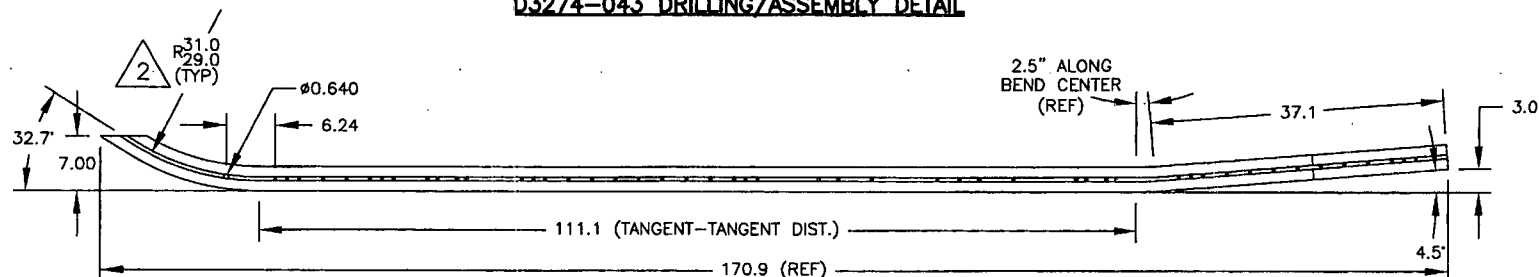
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

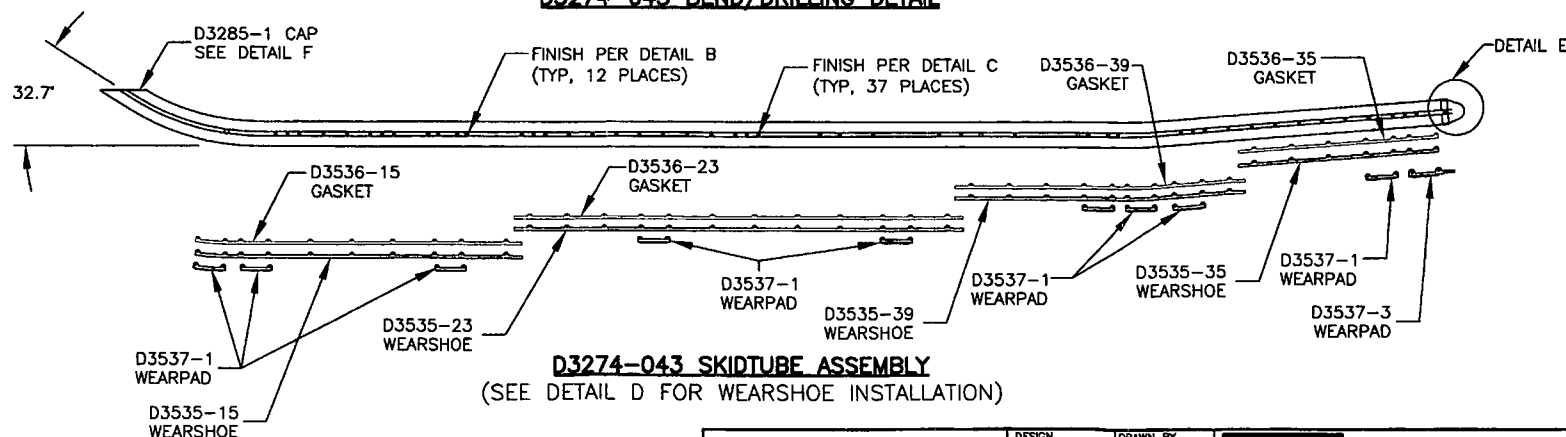
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	H	APPROVED	H	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 3 OF 4 SCALE 1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

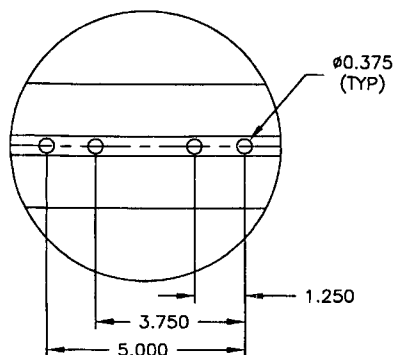
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

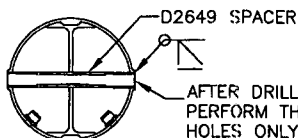
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A: DRILL DETAIL

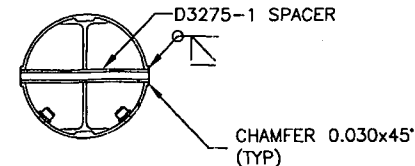


DETAIL B FOR 0.375 HOLES ONLY

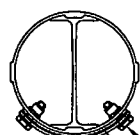


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY



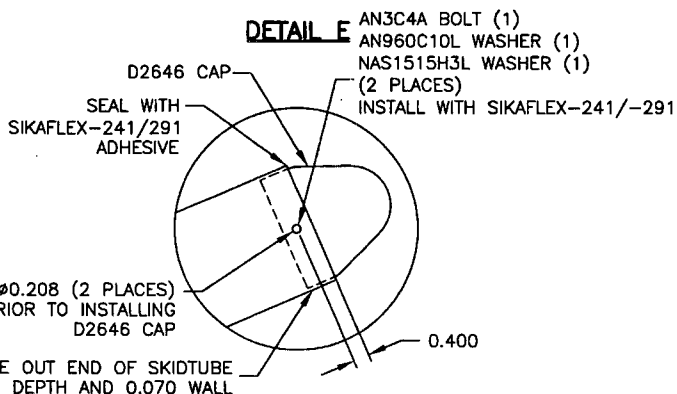
DETAIL D



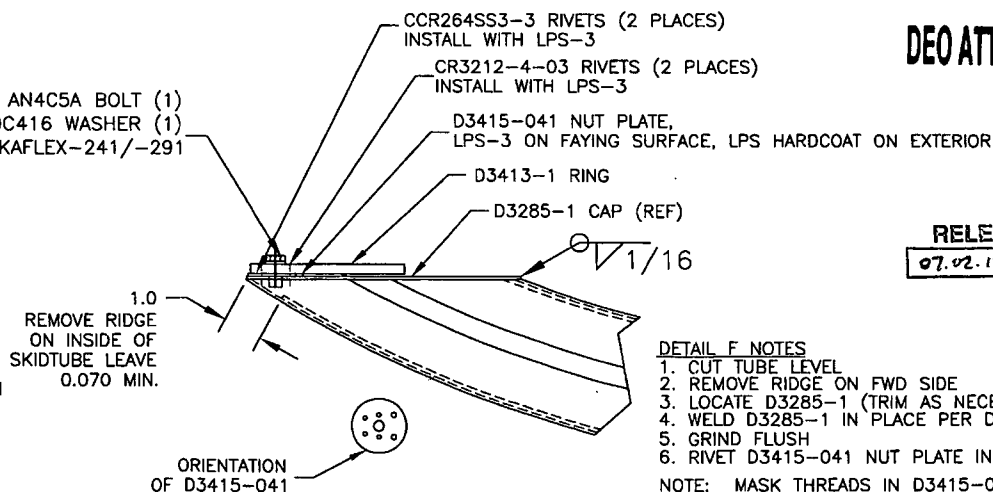
ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E



DETAIL F: END FINISHING DETAIL



DETAIL F NOTES
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DEO ATTACHED

RELEASED
07.02.12

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		DATE	06.12.19			TITLE	SKIDTUBE ASSEMBLY
						REV. 0	SHEET 4 OF 4
						SCALE	1:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23		DATE 09.06.23		

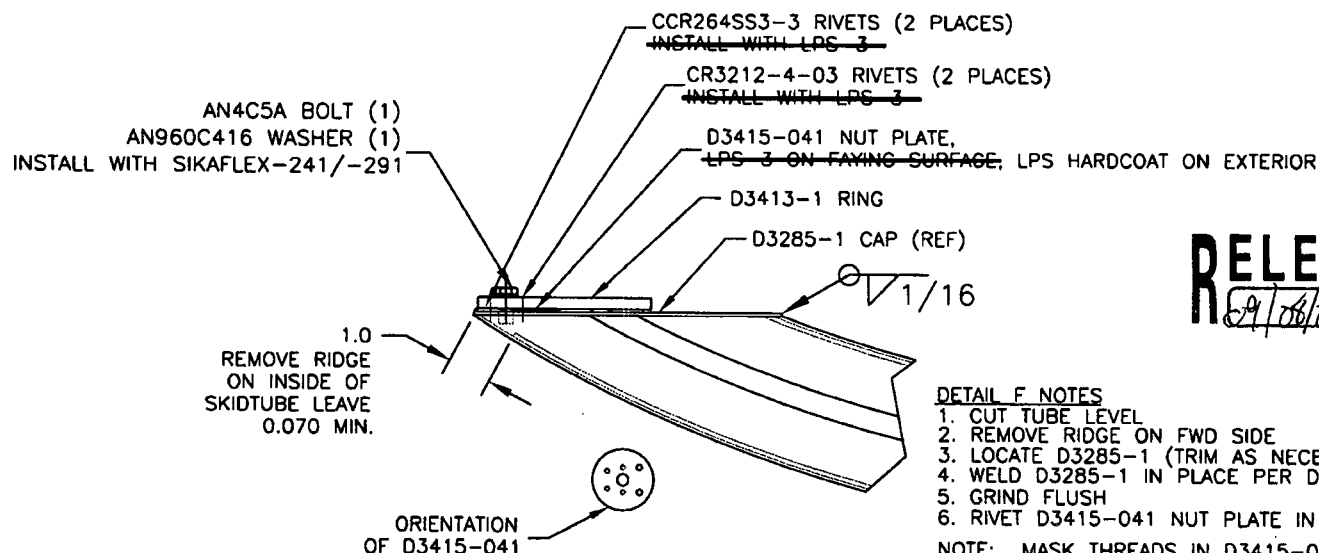
LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

u/o 43377

DETAIL F: END FINISHING DETAIL



RELEASED
09/06/23

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 241

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 62250
Part number: D206-42-541
Description: 206 skid
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier P.D.D. Date of Test Coupon 10-09-30
Welder Barclay Elliott Date of Test Coupon 10-09-30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.